

SPLIT-1

Dart Aerospace Ltd.

Date: Thursday, 01/05/2008 11:56:53 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPAD
 Job Number : 38941
 Estimate Number : 12712
 P.O. Number :
 This Issue : 01/05/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL /MED FAB
 Previous Run : 38254
 Written By :
 Checked & Approved By : ND 08-5-01
 Comment : Est Rev:A New Issue 07-02-14 JLM

Part Number : D35371
 Drawing Number : D3537 REV C
 Project Number : N/A
 Drawing Revision : C
 Material :
 Due Date : 10/05/2008 Qty: 72 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



16



Comment: Qty.: 0.1113 sf(s)/Unit Total: 11.1300 sf(s)

M304S16GA .063" 304 SS SHEET

Batch: 01772 HB 8-5-5

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3537

Dwg Rev: C HB 8-5-5

Prog Rev: C

2-Deburr if necessary HB 8-5-5

(119)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 8-5-5



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

08/05/05 (119) counts

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D3537-1

HB 08/05/06 (119)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 01/05/2008 11:56:53 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

Batch

2059B Hardcoat

M106834

1-Weld per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

FL 08/06/20 72x

7.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08/06/23 (72)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/06/23 (72) counter

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

1:30

OVEN TEMPERATURE:

320°

FINISH TIME:

2:00

FL 08/06/23 (72)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-06-23

(72)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-20

FL 08/06/23 (72)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/25

Job Completion



08/06/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

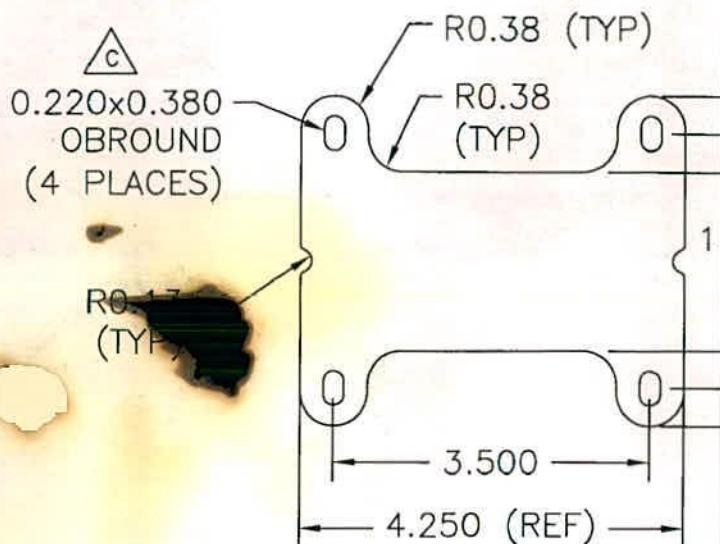
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

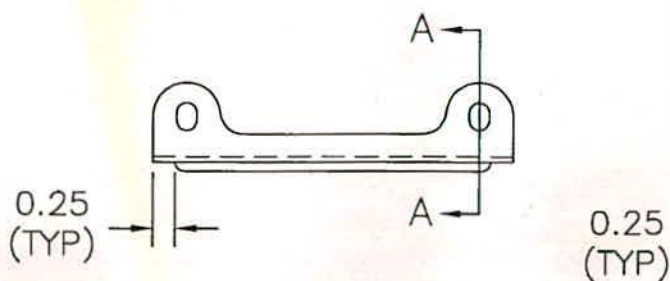
NOTE: Date & initial all entries



D3537-1F FLAT PATTERN



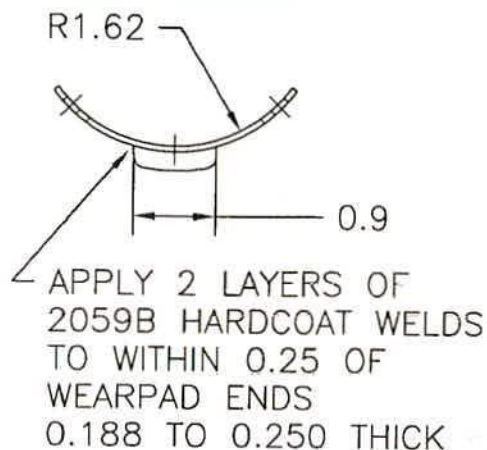
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



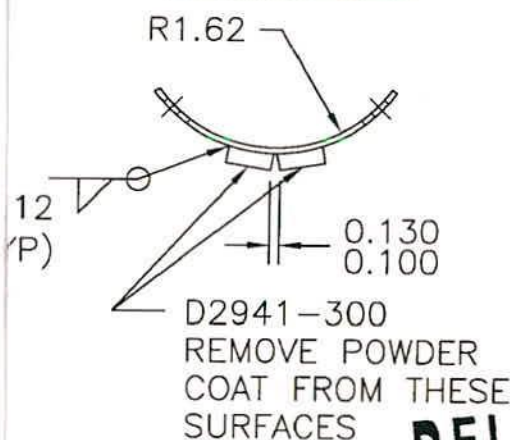
D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET (REF DART SPEC. M30)
- 2) BREAK ALL SHARP CORNERS 0.063
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SAND
- 5) TOLERANCES ARE PER DART QSI 004
- 6) ALL DIMENSIONS ARE IN INCHES

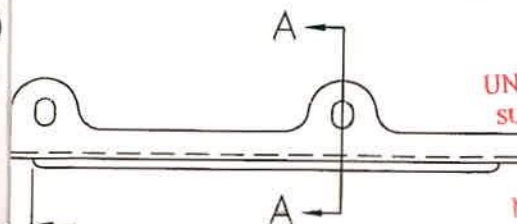
SECTION A-A



SECTION B-B



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



RELEASED
07.05.08 PH
per ELN 952

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 3841

4.13	WIDEN TAB TO 0.380, WELD PATTERN
3.20	ADD AMS 5513 AND AMS 5524
1.06	NEW ISSUE
BY PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWING NO. D3537	REV. C SHEET 1 OF 1
TITLE WEARPAD	SCALE 1:2

